



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9364	REV. B SHEET 1 OF 1
DATE 07.03.20	TITLE BUSHING INSTALLATION		SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	

## DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

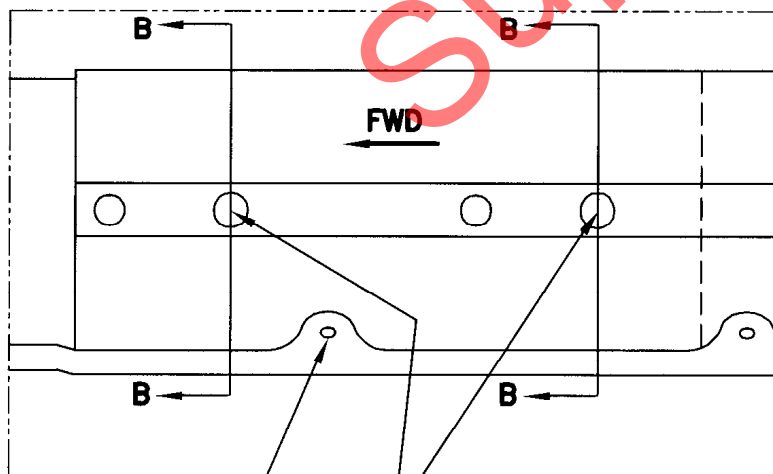
CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ( $\varnothing 0.500 \pm_{0.000}^{0.006}$ ) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



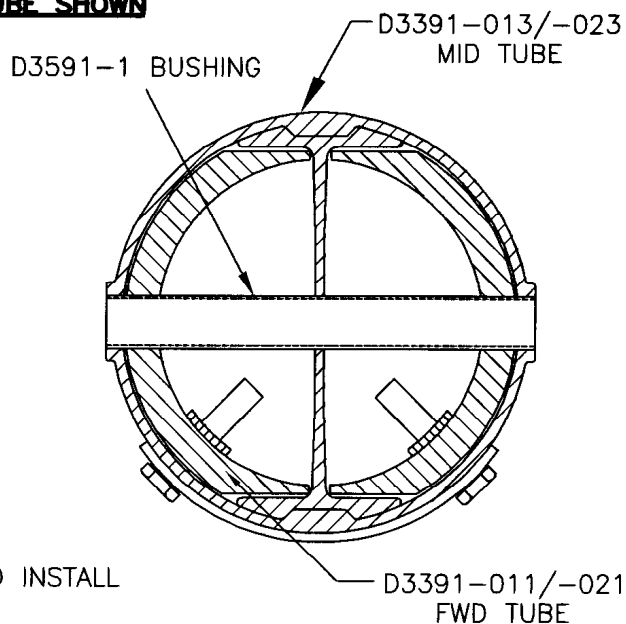
### D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED  
PRIOR TO TRANSFER DRILLING  
(REF)

OPEN TO  $\varnothing 0.500 \pm_{0.000}^{0.006}$  AND INSTALL  
D3591-1 BUSHING  
(2 PLACES)

### DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



### SECTION B-B

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